

Date: Wednesday, 03/09/2008 10:33:00 AM  
User: Julie Lecocq

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	AFT TUBE ASSEMBLY
<b>Job Number</b> :	41756		
<b>Estimate Number</b> :	10699		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3391025
<b>This Issue</b> :	03/09/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3391 REV G
<b>First Issue</b> :	1 / 1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41755	<b>Drawing Revision</b> :	G
	<b>Type</b> :	<b>Material</b> :	
	SKIDTUBES	<b>Due Date</b> :	20/09/2008
<b>Written By</b> :		<b>Qty:</b>	1
<b>Checked &amp; Approved By</b> :	JUD 08.9.03	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manuf. Instructions JLM  est rev D 07.03.20 revF dwg EC est rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD Est Rev:F 07-11-13 ECN 1056 DD verified by: EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
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**Comment:** Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D6014-090	Extrusion	B32309

Identify as D3391-3

a.m 08.09.11 (2)

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: 6

a.m 08.09.11 (1)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

a.m 08.09.11 (1)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS

1-Machine as per Folio FA 599 Rev: 6 & Dwg D3391 Rev: 6

2-Deburr

H.A 08/09/23

26 08/09/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 10:33:00 AM  
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## Process Sheet

Customer: CSDAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 41756

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/09/23

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/09/28

(1)

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

SL 8-10-3

8.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

KT 08-10-03

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP

8-10-3

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

Tools: rill

SL 8-10-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 41756

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*8-10-9*

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*SL 8-10-5*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*① H 8-10-5*

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: *41863*

*SL 8-10-5*

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: *1089116*

exp. date: *9-10-1*

cure time 12hrs as per QSI0015

*SL 8-10-5*

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06/10/09* *①* *8-10-9*

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: *8:30*

OVEN TEMPERATURE: *323*

FINISH TIME: *9:00*

*08/10/11*

*M. H. 08/10/11*

*①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24

(X)

19.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part NumberDescription Batch

1

D2646

Aft Cap

B41435

HL

20.0

D35371

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

B42351

HL

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

B33869

HL

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B33868

HL

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B33870

HL

24.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PHENOLIC WASHER

B339275

HL

25.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

batch: M105819

HL

08-11-24

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 41756

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent per  
QSI 017

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

or equivalent

Per QSI 017

M100621 MS

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	M109431

MS

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M109752

MS

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	M109798

M109798

MS

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

✓ 1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

✓ A/R Sikaflex-241/-291 M109449

Sikaflex expiry date: 08/11

MS

08-11-24

MS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 41756

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/11/25 40*

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*41684A*

*P/N 41684 P 8/4/25*

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/11/25*

Job Completion



*mf 08-11-25*

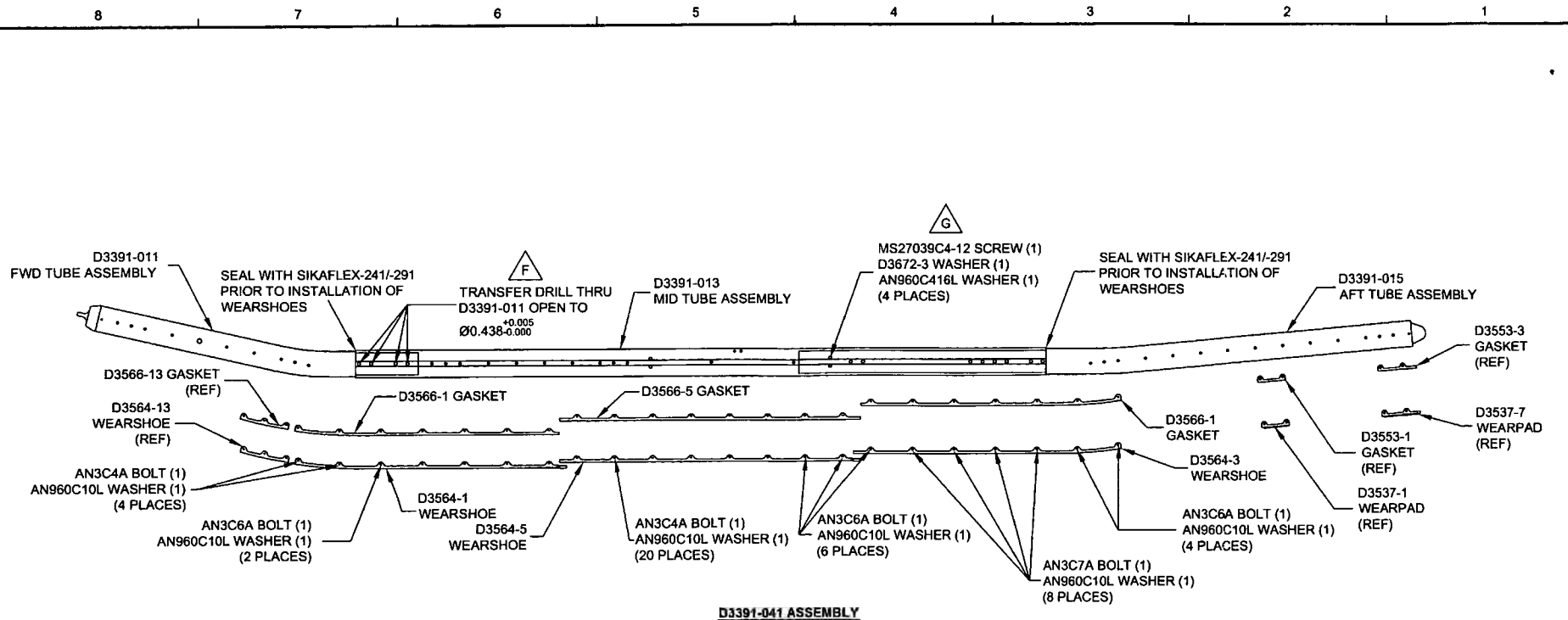
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
07-11-06

#### D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3566-13	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C418L	WASHER

#### GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

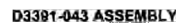
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWJ SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. REV. G  
D3391 SHEET 1 OF 8  
TITLE SCALE  
412 FLOAT SKIDTUBE NTS

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WORK ORDER  
NO. 417520

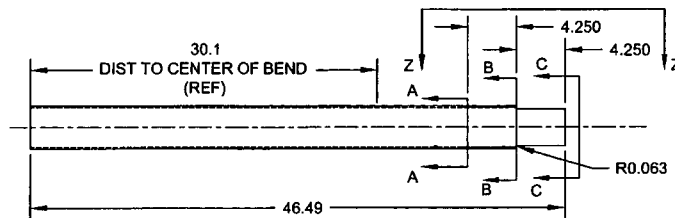


### D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

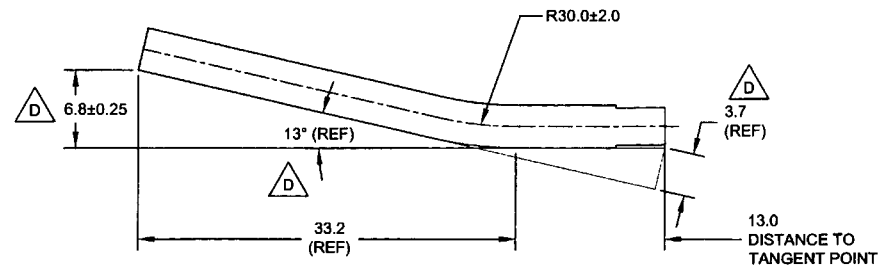
### GENERAL NOTES

- |               |                    |   |            |
|---------------|--------------------|---|------------|
| DESIGN        | <i>PH</i>          | <b>DART AEROSPACE USA, INC</b>  |            |
| DRAWN         | <i>JLC</i>         | <b>PORT ADRIAC, WA</b>  |            |
| CHECKED       | <i>[Signature]</i> | DRAWING NO.   | REV. (     |
| MFG. APPR.    | <i>[Signature]</i> | D3391   | SHEET 2 OF |
| APPROVED      | <i>[Signature]</i> | TITLE   | SCALE      |
| DE APPR.      | <i>[Signature]</i> | 412 FLOAT SKIDTUBE  | NT         |
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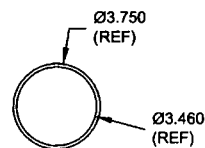
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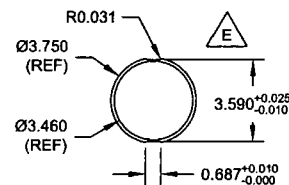
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



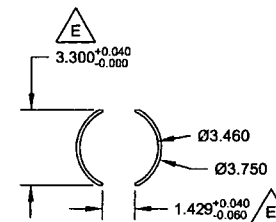
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



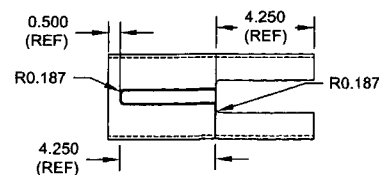
**SECTION A-A**  
(SCALE 1:5)



**SECTION B-B**  
(SCALE 1:5)



**SECTION C-C**  
(SCALE 1:5)



**VIEW Z-Z**  
(SCALE 1:5)

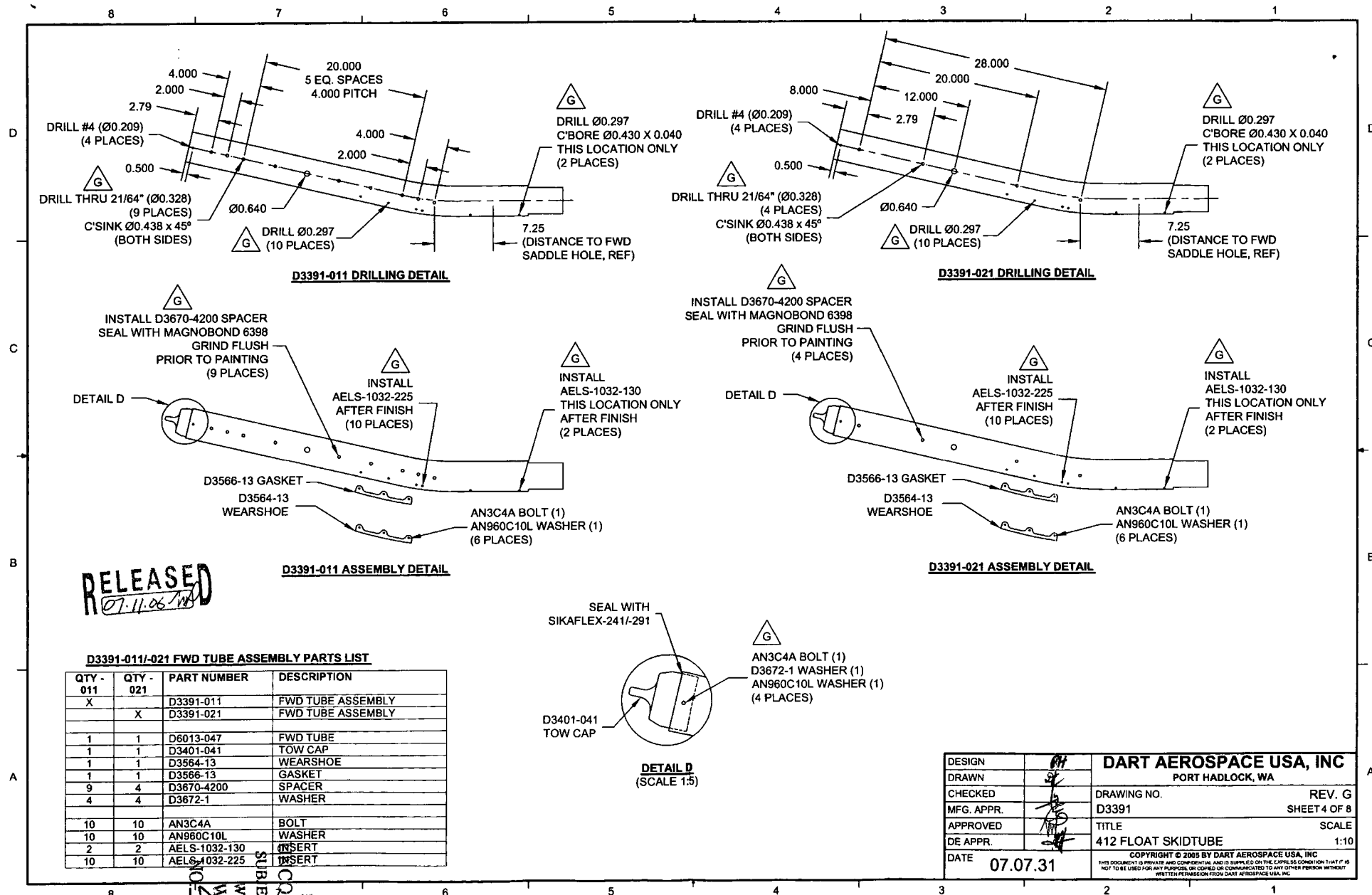
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07-11-08 114

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NO. 41754

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DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:10
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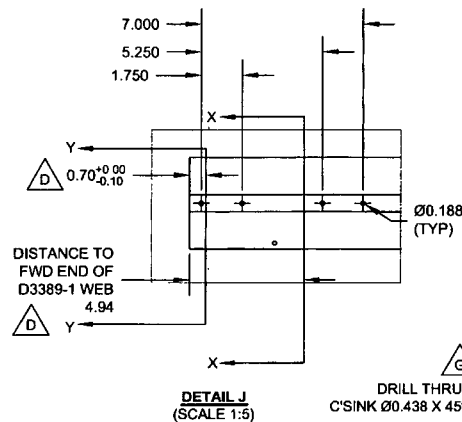




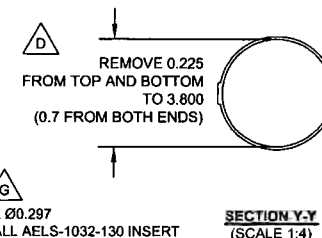
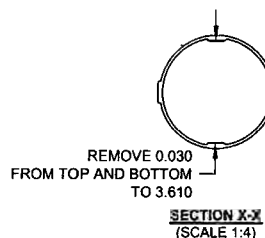
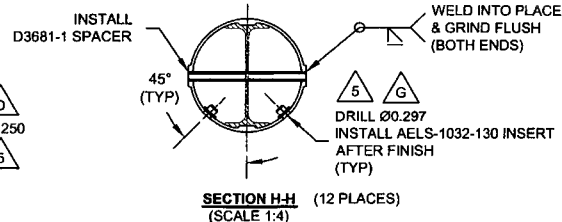
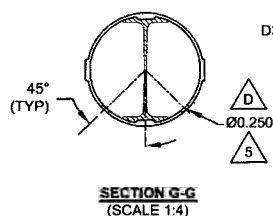
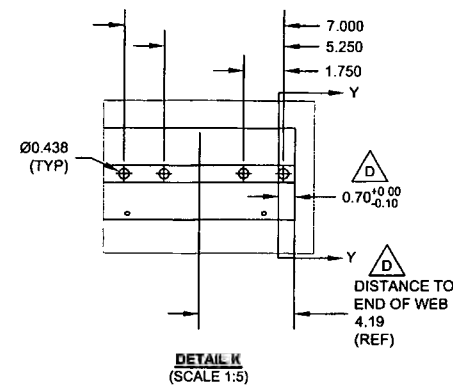
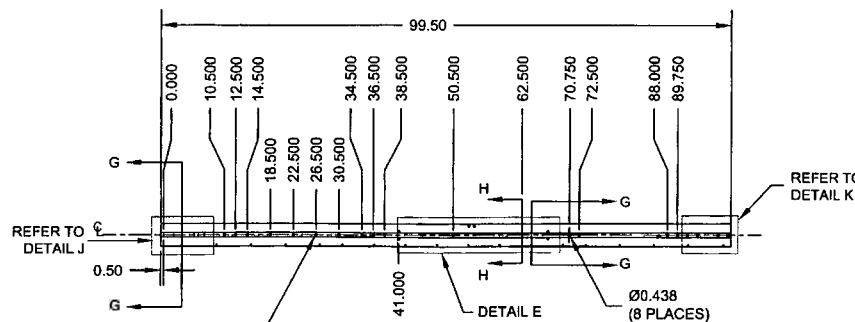
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WORK ORDER  
071756



8 7 6 5 4 3 2 1

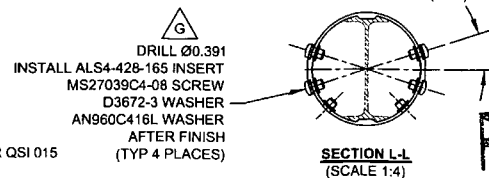
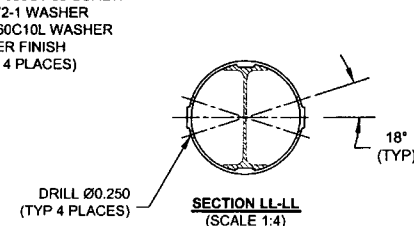
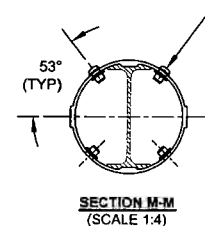
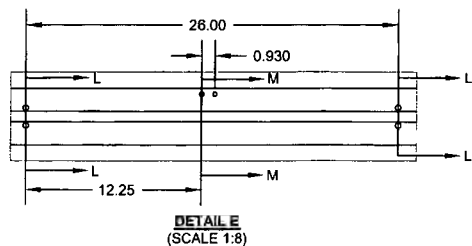


DRILL THRU 21/64" (Ø0.328)  
C'SINK Ø0.438 X 45° (BOTH SIDES)  
(12 PLACES)



# **D3391-013 MID TUBE ASSEMBLY PARTS LIST**

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	JP	PORT HADLOCK, WA
CHECKED	JP	DRAWING NO. D3391
MFG. APPR.	JP	REV. G
APPROVED	JP	SHEET 5 OF 8
DE APPR.	JP	TITLE 412 FLOAT SKIDTUBE
DATE	07.07.31	SCALE 1:20

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER WEB USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART 0104

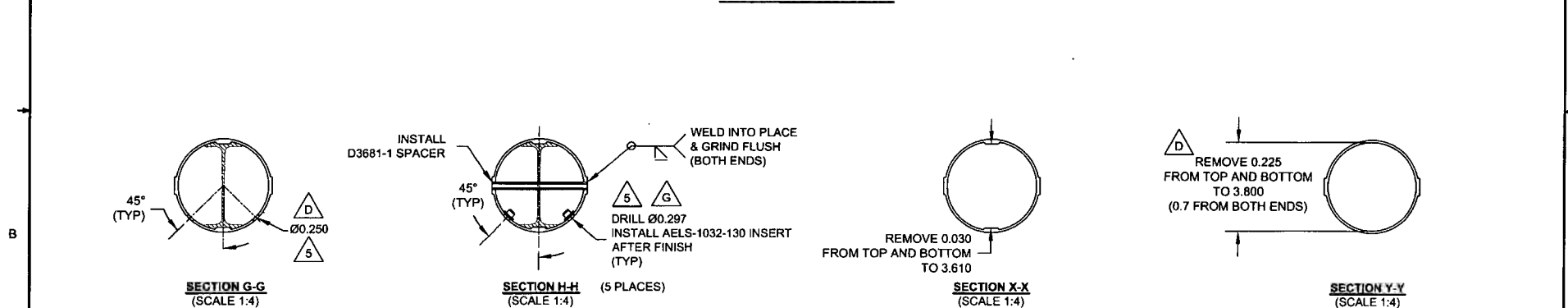
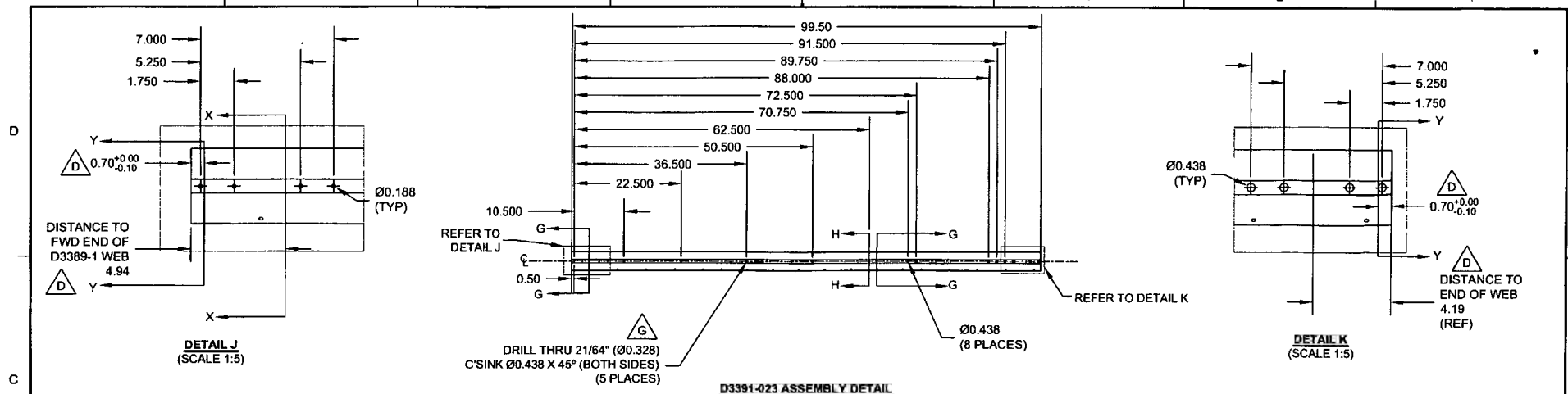
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ORDER 41254

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

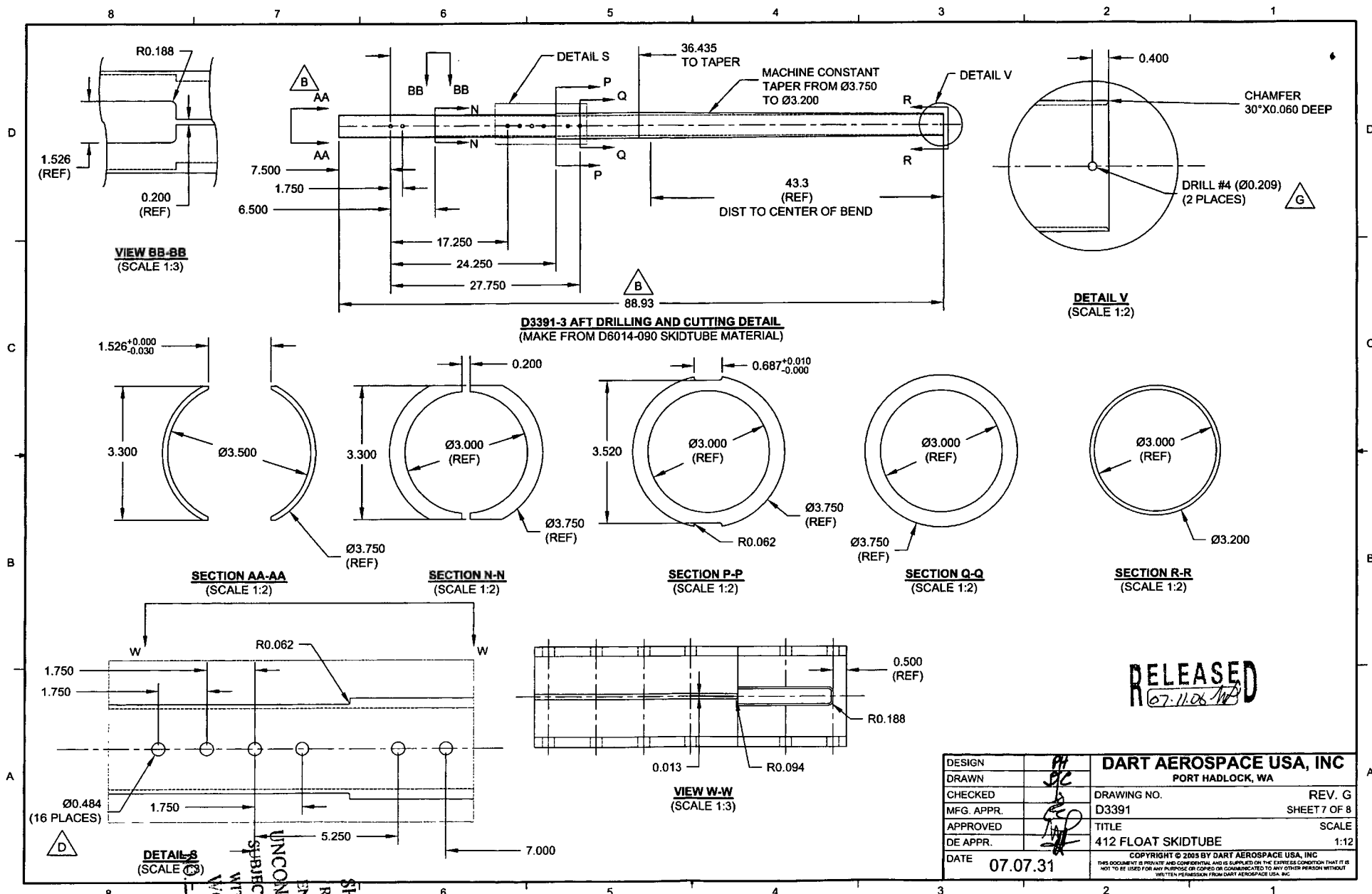
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO MID TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 015

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07.11.06

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	DE	PORT HADLOCK, WA	
CHECKED	h	DRAWING NO.	REV. G
MFG. APPR.	h	D3391	SHEET 6 OF 8
APPROVED	h	TITLE	SCALE
DE APPR.	h	412 FLOAT SKIDTUBE	1:20
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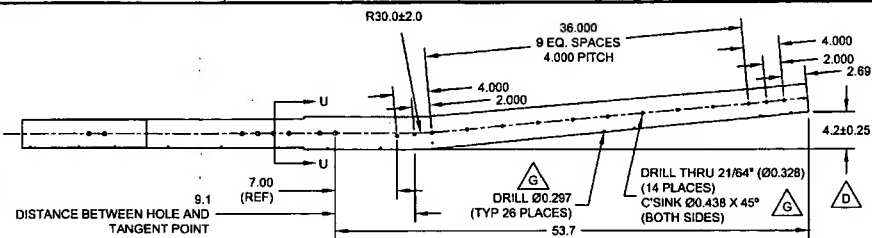


DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. G
MFG. APPR.	SC	D3391	SHEET 7 OF 8
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	412 FLOAT SKIDTUBE	1:12
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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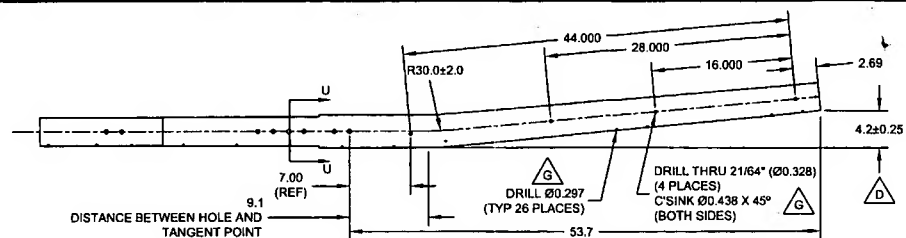






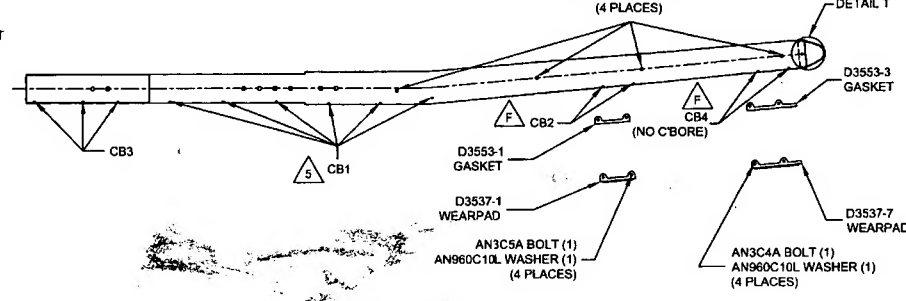
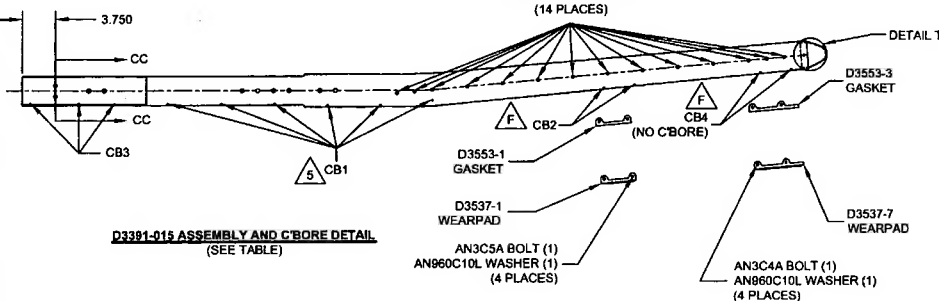
**D3391-015 BENDING AND DRILLING DETAIL**  
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER  
SEAL WITH MAGNOBOND 6398  
GRIND FLUSH  
PRIOR TO PAINTING  
(14 PLACES)



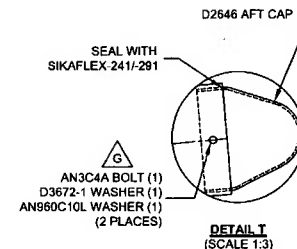
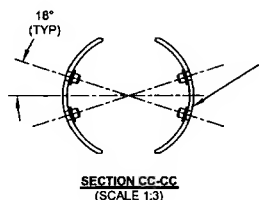
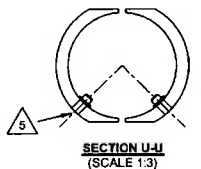
**D3391-025 BENDING AND DRILLING DETAIL**  
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER  
SEAL WITH MAGNOBOND 6398  
GRIND FLUSH  
PRIOR TO PAINTING  
(4 PLACES)



**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



**RELEASED**  
07-11-06

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND  
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	DK	PORT HADLOCK, WA
CHECKED	SK	DRAWING NO. REV. G
MFG. APPR.	SK	D3391 SHEET 8 OF 8
APPROVED	SK	TITLE SCALE
DE APPR.	SK	412 FLOAT SKIDTUBE 1:12
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> B41756
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> G	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.493	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	44.995	✓			
3.200	+/-0.010	3.203	✓			
1.526	+0.000/-0.030	1.510	✓			
0.200	+/-0.010	0.200	✓			
7.500	+/-0.010	7.498	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.300	✓			
0.200	+/-0.010	0.200	✓			
3.520	+/-0.010	3.520	✓			
0.687	+0.010/-0.000	0.688	✓			
R0.062	+/-0.010	R0.062	✓			
Ø0.484	+0.005/-0.001	Ø0.488	✓			

<b>Measured by:</b> G.M./H.A. 08/09/23	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08.09.11	<b>Date:</b> 08/09/28	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	[Signature]

